

Work Order ID 122254

122254

Page 1

Monday, July 14, 2014 1:54:10 PM

Item ID: D4634-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Middle, Center Ceiling Panel Assembly
Start Date: 8/08/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/08/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 14-07-14 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4634 | F |

| | | | | | | | | | |
|------------------------------|----------|------|--|--|--|--|--|-------------------|--|
| 100 | | 0.00 | | | | | | DAS 27 9-89 | |
| *100* | | | | | | | | | |
| HandThermo | Memo | 0.00 | | | | | | | |
| Hand Finishing Thermoforming | Pick Kit | | | | | | | | |

| | | | | | | | | | |
|--------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|--|--|--|--|--|-------------------|--|
| 110 | | 0.00 | | | | | | DAS 27 9-89 | |
| *110* | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | ***BEFORE INTALLING D4728-051, APPLY A 3/16" SEEM OF PLASTIC-WELD 2 ON TOTAL LENGHT OF PART ON EANCH SIDE OF LIGHT, LET DRY FOR ONE HOUR*** PLASTIC-WELD 2 BATCH: <u>M129001</u> | | | | | | | | |

- 1- Assemble as per Dwg D4634-043
- 2- Install led lights
- 3- Install Air valves
- 4-Install wiring harness

3/17/2015

4/8/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Work Order ID 122254

Monday, July 14, 2014 1:54:10 PM

122254

Page 2

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Revision ID: Stop ***NS2***
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|-----------------------------------------------|------|--|--|--|--|--|--|--|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

① 14-0821 PD

| | | | | | | | | | |
|--------------|---------------------------------------------|------|--|--|--|--|--|--|--|
| 130 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

① DAS 06 9-89 AUG 27 2014

| | | | | | | | | | |
|-----------------|---------------------------------------------|------|--|--|--|--|--|--|--|
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MLC 14-0827

① 14-8.27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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FAULT CATEGORY

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Picklist Print

Monday, July 14, 2014 1:54:09 PM

Page 1

Work Order ID: 122254

122254

Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 8/08/14

Required Date: 8/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Doc Release DL VERIFIED BY:JLM
13/07/09 DL verf: DD
DL
IPP Rev B
IPP Rev C Dwg Update
IPP Rev. D Dwg Update 13/12/23
IPP REV E Dwg Update 14/01/20 DL

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D4634-143

Manufactured

No

100

Each

0.0000

1

1

D4634-143

Middle, Center Ceiling Replacement Panel Assembly

D4646-1

Manufactured

No

100

Each

61.0000

2

2

D4646-1

Plenum Cap Assembly

Location

Loc Qty

Loc Code

MF3

61

114006

46

114625

15

D4652-1

Manufactured

No

100

Each

26.0000

2

2

D4652-1

Air Valve, 1.16 Id Disk Type

Location

Loc Qty

Loc Code

MF

23

116424

23

MF3

3

111777

3

D4728-053

Manufactured

No

100

Each

7.0000

1

1

D4728-053

Cabin Lights #2

Location

Loc Qty

Loc Code

MF

7

116299

5

116300

1

117915

1

DAS
27
9-89

14/8/20

DAS
27
9-89

14/8/20

DAS
27
9-89

14/8/20

DAS
27
9-89

14/8/20

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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| Offset/Setup | | | | | | | | | |
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Picklist Print

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Page 2

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Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 8/08/14

Required Date: 8/08/14

Start Qty: 1.00

Required Qty: 1.00

PLT1.5M-M

Purchased

No

100

Each

1,392.000

3

3

}

PI T1 5M-M

Tie Wrap

Location

Loc Qty

Loc Code

ST389

1392

124363

2

m126551

390

m129712

1000

2351-20-27-C3C

2351-20-27-
Z3CT

Purchased

No

100

Each

57.0000

2

2

2351-20-27-C3C

STUD

Location

Loc Qty

Loc Code

MF5

29

m126740

2

m128068

27

ST396

28

m127922

28

50-009-2

Purchased

No

100

Each

434.0000

2

2

50-009-2

Grommet

Location

Loc Qty

Loc Code

MF5

8

m128022

8

ST378

426

122594

1

m128022

9

m128047

416

2

DAS
27
9-89

14/8/20

DAS
27
9-89

14/8/20

DAS
27
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14/8/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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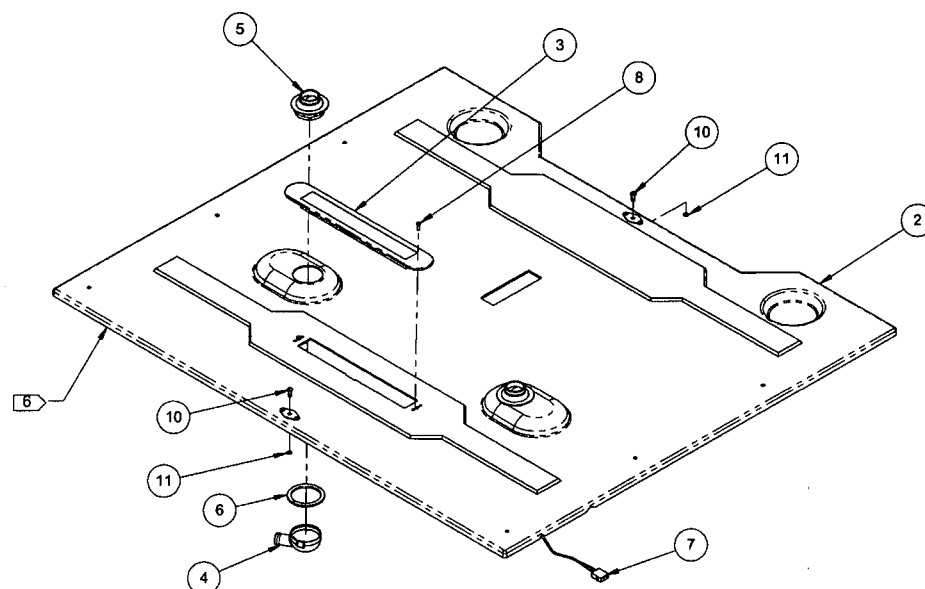
| | | | | | | | | | | | | | | | | | | |
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| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

| ITEM NO. | QTY. -043 | PART NUMBER | DESCRIPTION |
|----------|--------------|----------------|-----------------------------------------------|
| 1 | X | D4634-043 | MIDDLE, CENTER CEILING PANEL ASSY |
| 2 | 1 | D4634-143 | MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY |
| 3 | 1 | D4638-1 (REF) | LED LIGHT (REF PART OF D4728-051) |
| 4 | 2 | D4646-1 | PLENUM CAP ASSEMBLY |
| 5 | 2 | D4652-1 | AIR VALVE |
| 6 | 2 | D4652-3 (REF) | MOUNTING NUT (PART OF D4652-1) |
| 7 | 1 | D4728-053 | CABIN LIGHT #2 HARNESS ASSEMBLY |
| 8 | 2 | N/A (REF) | SCREW (PART OF D4728-053) |
| 9 | 3 | PLT1.5M-M | TIE-WRAP (OR PLT1.5M-C) |
| 10 | 2 | 2351-20-27-C3C | STUD |
| 11 | 2 | 50-009-2 | GROMMET |



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

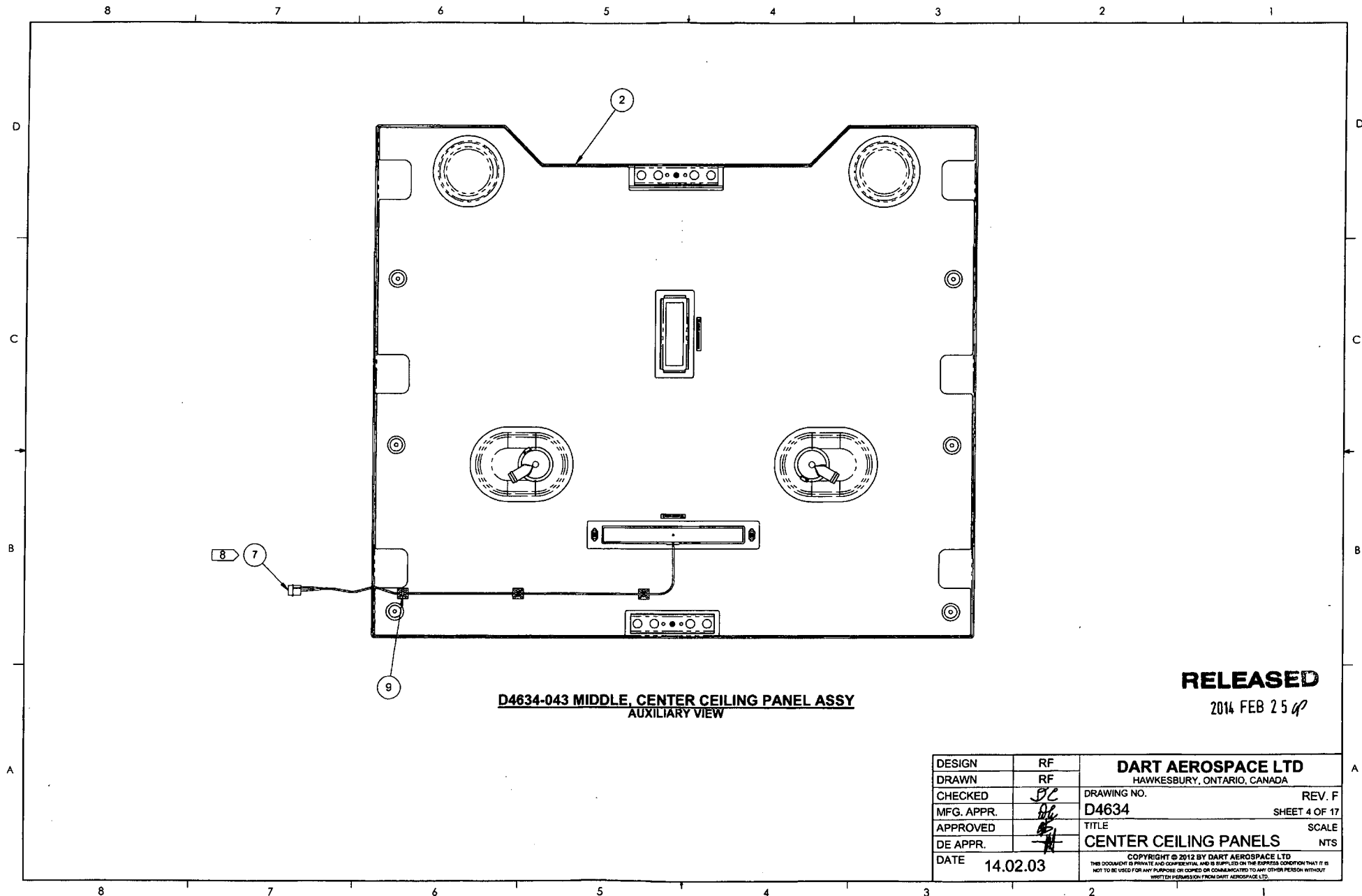
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| DRAWN | RF | | |
| CHECKED | BC | DRAWING NO. | REV. F |
| MFG. APPR. | BC | D4634 | SHEET 3 OF 17 |
| APPROVED | BC | TITLE | SCALE |
| DE APPR. | BC | CENTER CEILING PANELS | NTS |
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2014 FEB 25 *ap*

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| DRAWN | RF | | |
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